

31

Date: Monday, 7/16/2007 2:44:44 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE  
 Job Number : 33555  
 Estimate Number : 10366  
 P.O. Number : *N/A*  
 This Issue : 7/16/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : LANDING GEAR  
 Previous Run : 33526  
 Part Number : D412742013  
 Drawing Number : *N/A*  
 Project Number : *N/A*  
 Drawing Revision : *N/A*  
 Material : *N/A*  
 Due Date : 7/30/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: A 05.10.13 New Issue KJ/JLM  
 Est Rev: B 06-06-08 As per DSI9336 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003

*Er 07/08/07*

2.0 33555A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B *33555A**7/8/07**sq*

3.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2571 Saddle Fwd Outside

*1331647**sq*

4.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2572 Saddle Fwd Inside

*31714**sq*

5.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2573 Saddle Aft Outside

*1331717**7/7/07 sq*

Date: Monday, 7/16/2007 2:44:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33555

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2574 Saddle Aft Outside 33043 ✓

sq

7.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2747 Bolt 1531300 ✓

sq

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2876 Saddle Spacer 1531227 ✓

sq

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2877 Saddle Spacer 1550055 ✓

sq

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D3403-1 Bushing 1532888 ✓

1532888 1533562 ✓

sq

11.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D3403-3 Bushing 1532889 ✓

7/7/24 sq

Date: Monday, 7/16/2007 2:44:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33555

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

132890 ✓

50

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

132891 ✓

59

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

1104936 ✓

50

15.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

119529 ✓

50

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

1100340 ✓

50

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

1104285 ✓

7/7/24 50

Date: Monday, 7/16/2007 2:44:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33555

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 32 AN960C416L

Washer

M104916 ✓

SD

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 8 AN960C616L

Washer

M18822 ✓

SD

20.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M104093 ✓

SD

M10 M13872

21.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M104936 ✓

SD

22.0

NAS1515H4L

Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 32 NAS1515H4L

Washer

M104956 ✓

7/7/24 SD

Date: Monday, 7/16/2007 2:44:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33555

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

NAS1515H6L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H6L

Washer

M18918 ✓ SP

24.0

NAS1515H7L

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H7L

Washer

M100727 ✓ SP

25.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

M30394 ✓ SP

26.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

M33519 ✓ SP

27.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

M33276 ✓ SP

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M101427 ✓

7/7/24 SP

Date: Monday, 7/16/2007 2:44:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33555

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/08/01

PC 7/8/01

EP 07/08/01

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location:

REV: D

EP 07/08/210 SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/08/22

Job Completion



1333442 A 407-08-22

31

Date: Monday, 7/16/2007 2:44:44 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE  
 Job Number : 33555  
 Estimate Number : 10366  
 P.O. Number :  
 This Issue : 7/16/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D412742013  
 First Issue : / / Type : LANDING GEAR Drawing Number : N/A  
 Previous Run : 33526 Drawing Revision : N/A  
 Material :  
 Due Date : 7/30/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.07.17  
 Comment : Est Rev: A 05.10.13 New Issue KJ/JLM  
 Est Rev: B 06-06-08 As per DSI9336 JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003

07.07.26 KJ

2.0

33555A

FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY  
 D412-742-043 B \_\_\_\_\_

3.0

D2571

Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside \_\_\_\_\_

4.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside \_\_\_\_\_

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside \_\_\_\_\_

REFERENCE ONLY

31

Date: Monday, 7/16/2007 2:44:58 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT SKID ASSEMBLY
Job Number : 33555A	
Estimate Number : 10756	
P.O. Number : <i>N/A</i>	Part Number : D412742043
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3391 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : F
Previous Run : 33526A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.07.17	
Comment : Est Rev A 05.10.13 New Issue KJ/JLM	
Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC	
Est Rev C 07-05-28 As per Rev F JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

*N/A  
 Attached with W/O 33525*

2.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

*B 31846*

*[Signature]*

3.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

*B 31858*

*[Signature]*

4.0

D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

*33243*

*45 07 07 29*



Date: Monday, 7/16/2007 2:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33555A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 33744 B33764 RT 07-07-29

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 32738 RT 07-07-29

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: 33458 RT 07-07-29

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 33483 RT 07-07-29

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: 104955 RT 07-07-29

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: 103693 RT 07-07-29

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: 103668 RT 07-07-29

Date: Monday, 7/16/2007 2:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33555A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: 105 057

85 07-07-27

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 1105085

M.A. 07/07/24 (1)

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 104989

85 07-07-27

Expiry date: 01-01-08

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R LPS Procyon 104271

A/R Sikaflex-241/-291 104989

Expiry date: 06-01-08

85 07-07-27

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

85 07/07/30 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP B33525

07/1/30

Date: Monday, 7/16/2007 2:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33555A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

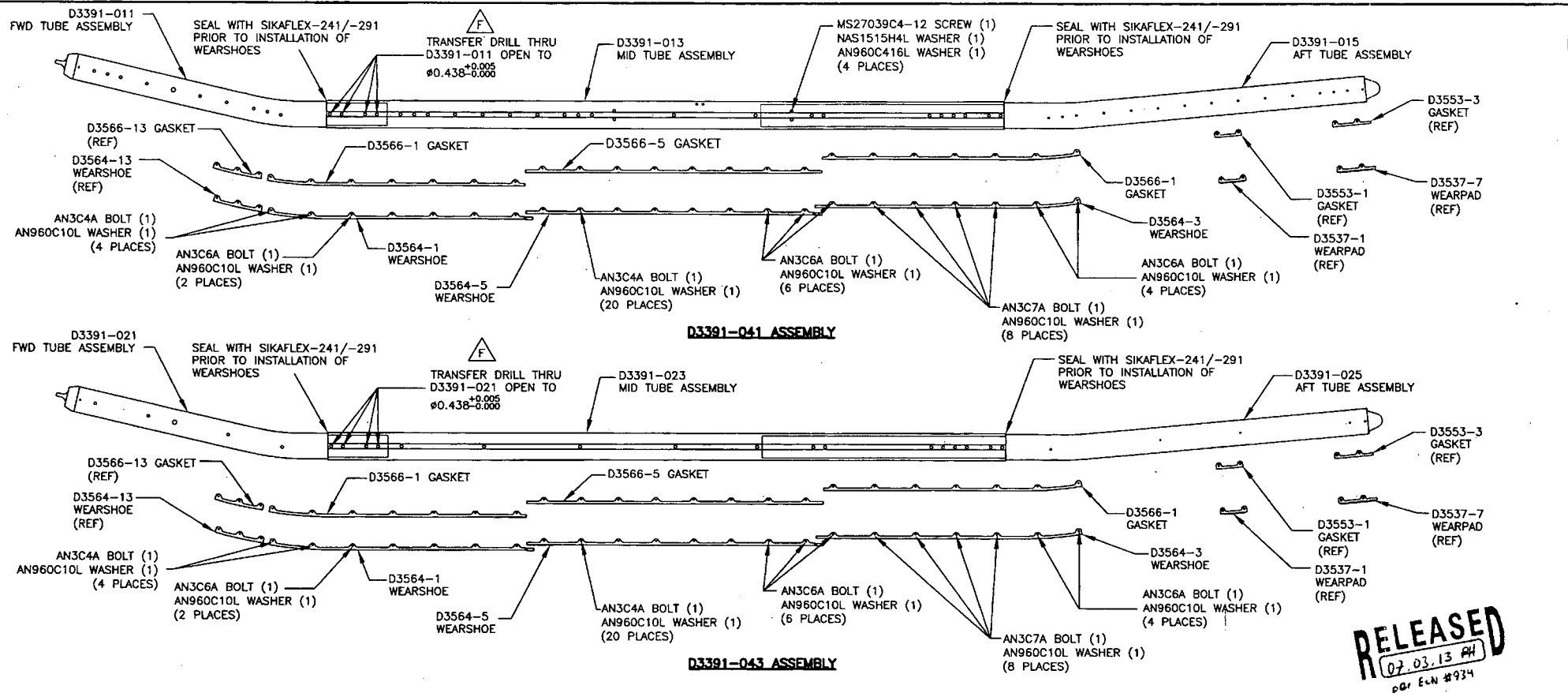
Comment: FINAL INSPECTION/W/O RELEASE

12/07/30

Job Completion



u 57-07-30



#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-5	WEARSHOE
1	1	D3564-3	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

#### GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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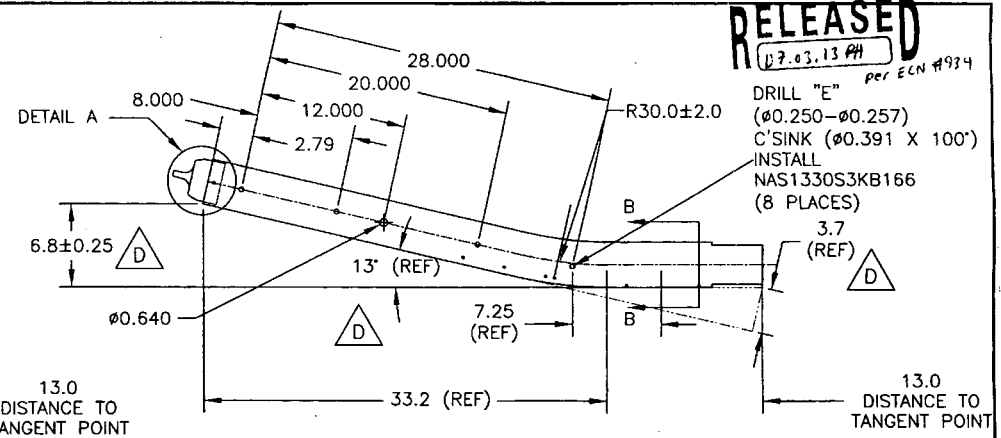
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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		DART AEROSPACE USA, INC.
		PORT HADLOCK, WA
		DRAWING NO.
		D3391
		REV. F
		SHEET 1 OF 5
		SCALE
		NTS

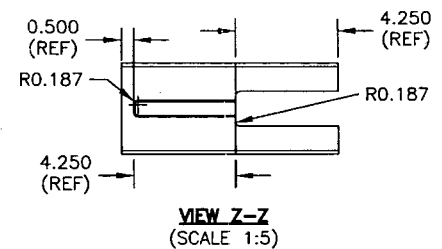
RELEASED  
07.03.13 PH  
per E.N. #934

WORK ORDER  
N335554  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT

DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100")  
INSTALL  
NAS1330S3KB166  
(8 PLACES)




**D3391-021 ASSEMBLY AND BENDING DETAIL**



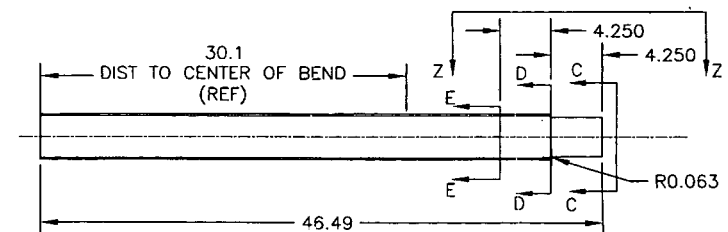
**VIEW Z-Z**  
(SCALE 1:5)

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE


 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

**SECTION B-B**  
(SCALE 1:5)




**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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DART AEROSPACE USA, INC.

DESIGN
--------

c. PH

CHECKED 

DATE 

07.01.18

DRAWN BY

PH

APPROVED

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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**DART**

**DART AEROSPACE USA, INC.**  
POST HADLOCK, WA

DRAWING NO.	D3391
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TIME	
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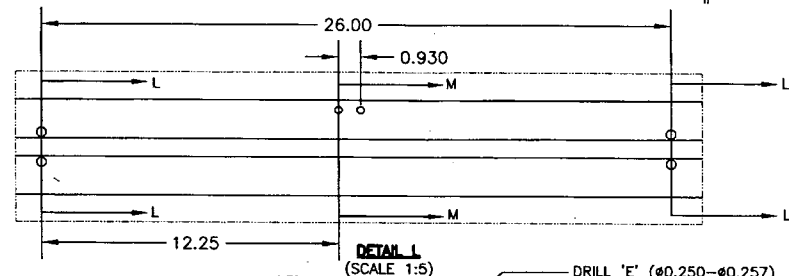
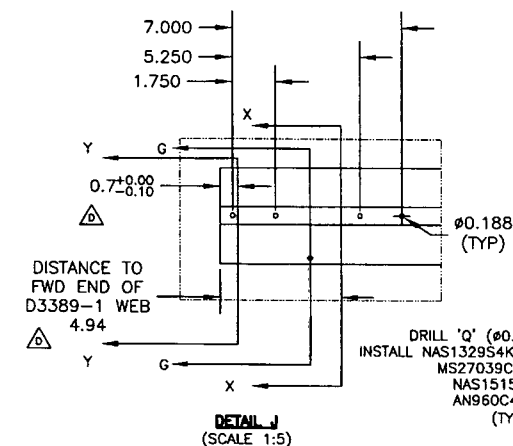
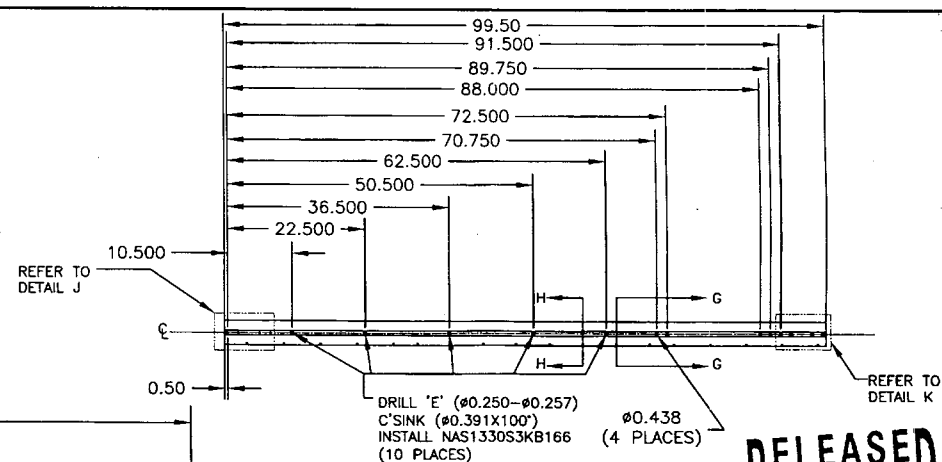
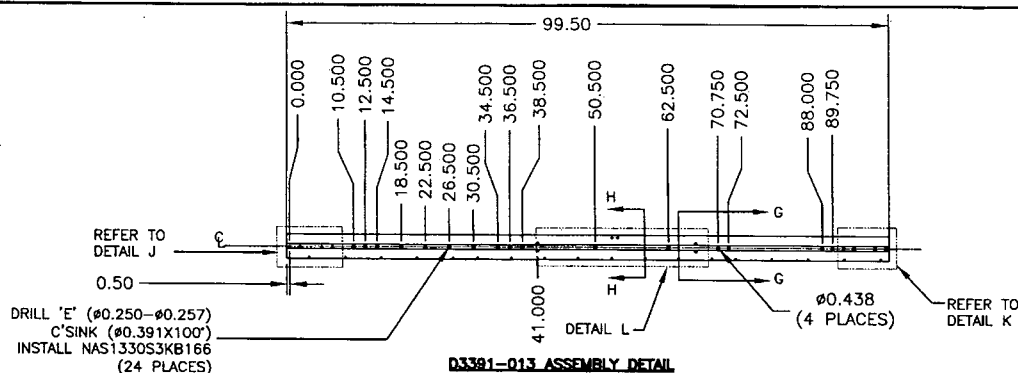
412 FLOAT SKIDTUBE

REV. F

SHEET 2 OF 5

SCALE

1:10



#### D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

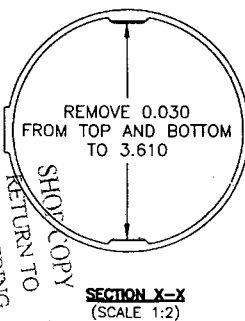
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

#### D3391-013/-023 MID TUBE ASSEMBLY

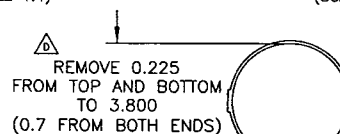
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSP 013

SECTION L-L  
(SCALE 1:4)

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WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOW COPY



SECTION M-M  
(SCALE 1:4)



SECTION LL-LL  
(SCALE 1:4)

SECTION G-G  
(SCALE 1:4)

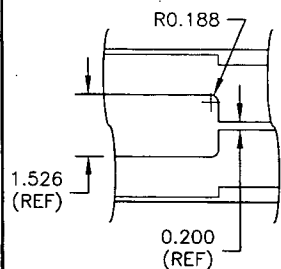
SECTION H-H  
(SCALE 1:4)

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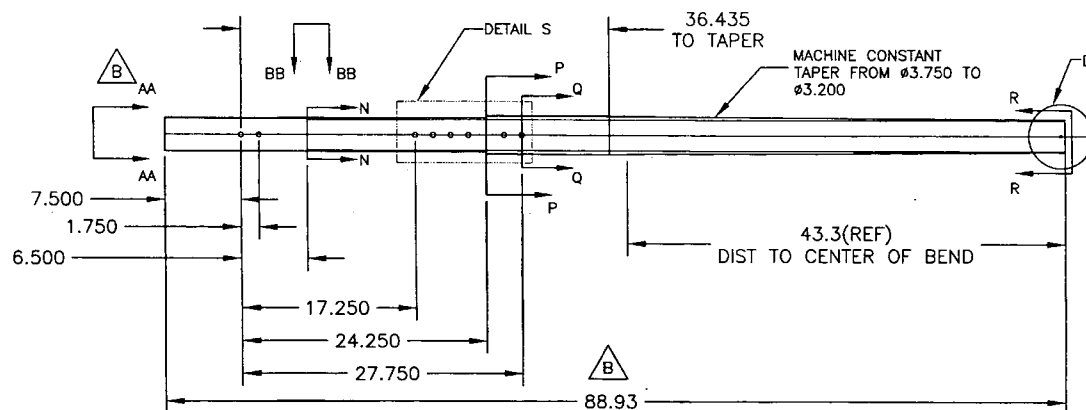
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CHECKED RH	APPROVED RH	DRAWING NO. D3391	SHEET 3 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	

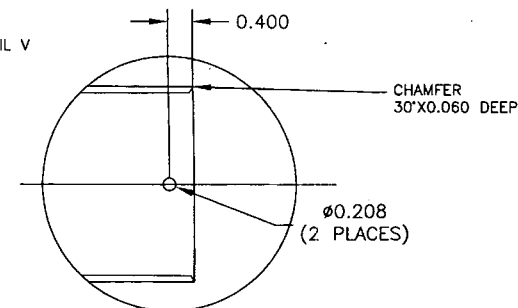
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07.05.13 RH  
Per ESN #934



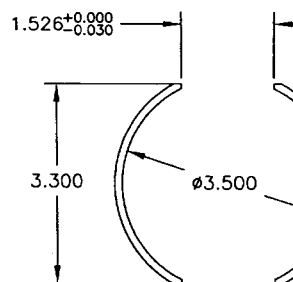
VIEW BB-BB  
(SCALE 1:3)



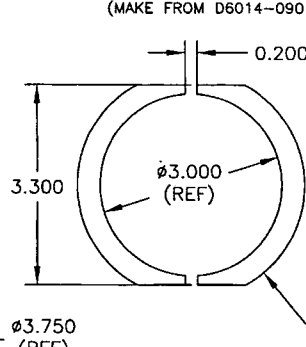
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



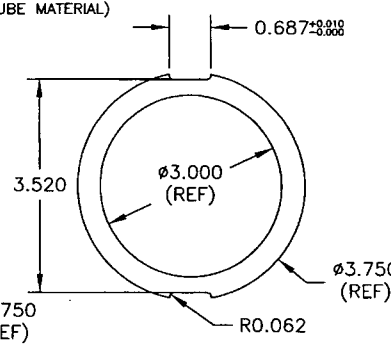
DETAIL V  
(SCALE 1:2)



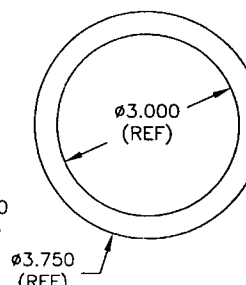
SECTION AA-AA  
(SCALE 1:2)



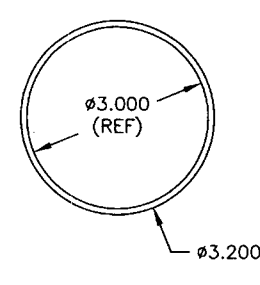
SECTION N-N  
(SCALE 1:2)



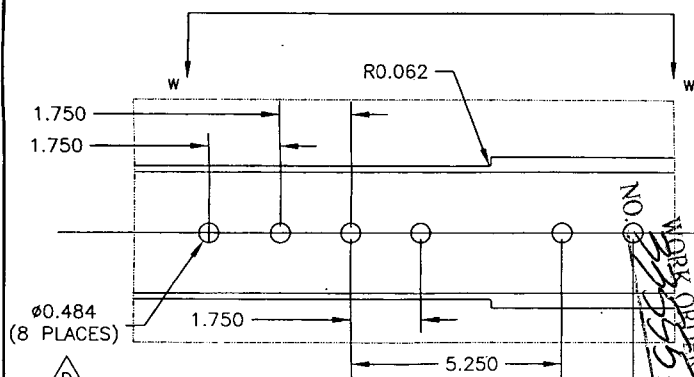
SECTION P-P  
(SCALE 1:2)



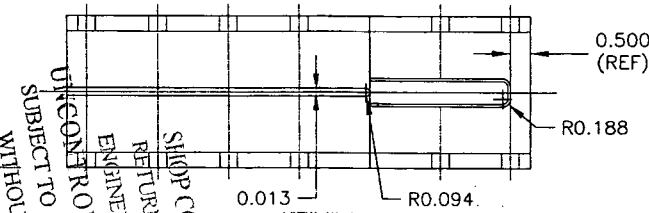
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

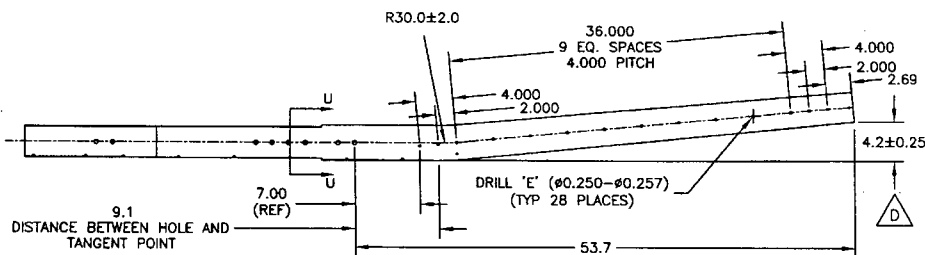
NO. 1000  
 WORK ORDER  
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 07-03-13 PH  
 per GEN #934

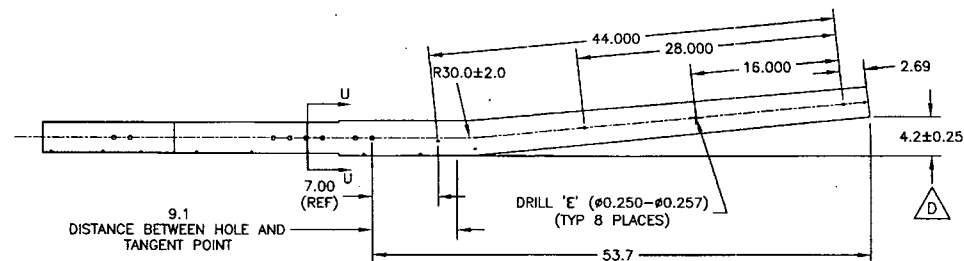
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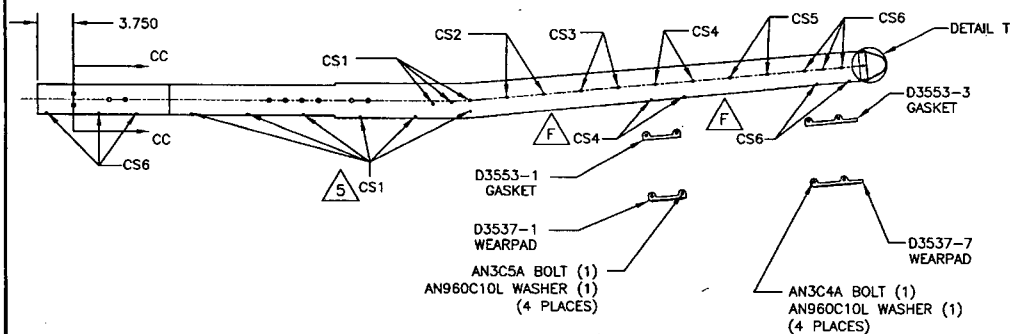
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. FORT HADLOCK, MA	REV. F SHEET 4 OF 5
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DATE 07.01.18	DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12



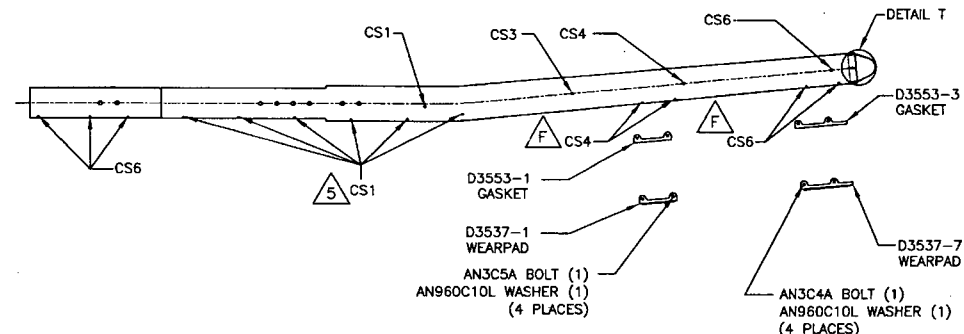
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

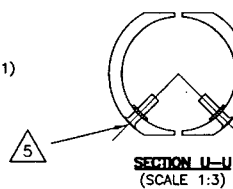
**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

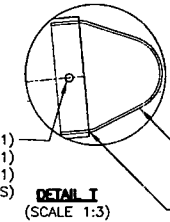
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WORK ORDER  
33555 A



DRILL 'Q' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100')  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



**SECTION U-U**  
(SCALE 1:3)



**DETAIL T**  
(SCALE 1:3)

AN3C4A BOLT (1)  
NAS1515H3L WASHER (1)  
AN960C10L WASHER (1)  
(2 PLACES)  
D2646 AFT CAP  
SEAL WITH SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 5 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

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